

Work Order ID 120954

July-10-14 10:24:57 AM

\*120954\*

Page 1

Item ID: D3531-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Bracket

Stop \*NS2\*

Start Date: 7/10/14 Start Qty: 10.00

\*10\* 9

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MW Date: 14-07-10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3531	B
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100

FLOW WATER JET

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3531

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(9) \_\_\_\_\_ mm 14/07/18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

(9) \_\_\_\_\_ mm 14/07/18

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\*120954\*

Page 2

Item ID: D3531-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 7/10/14

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 7/10/14

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

\*130\*

Brake NC

NC BRAKE

Bend as per dwg

Memo

0.00

Brake NC

DAS  
22  
9-89

14.07.21

DAS  
30  
9-89DAS  
36  
9-89

9

14/07/21

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

Dmp  
14/7/21

9

# Work Order ID 120954

**\*120954\***

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July-10-14 10:24:57 AM

Item ID: D3531-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 7/10/14

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 7/10/14

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

9 7/16/14 7:24

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

9x 7/14/14 10:25

170

Identify as per dwg & Stock Location G-A

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

9x 7/14/14 10:25

Work Order ID 120954

\*120954\*

Page 4

July-10-14 10:24:57 AM

Item ID: D3531-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Bracket

Stop \*NS2\*

Start Date: 7/10/14

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 7/10/14

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

MLJ 14-07-25  
H. 7-25

# Picklist Print

July-10-14 10:25:00 AM

Page 1

Work Order ID: 120954

**\*120954\***

Parent Item: D3531-1

**\*D3531-1\***

Parent Item Name: Bracket

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD  
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No		100	sf	127.7900	0.3783	4			

**\*M6061T6S 040\***

6061-T6 .040 Sheet

**\*\***

mm 14/07/14

Location

Loc Qty

Loc Code

MAT021

127.79

m128422

49.79

m129584

78

4.3

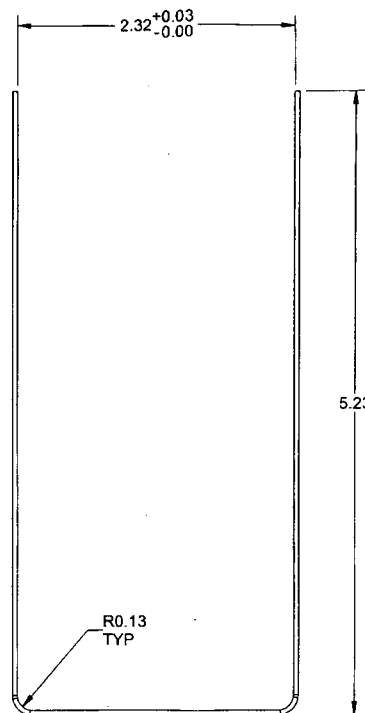
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	120959
<b>Description:</b> Bracket		<b>Part Number:</b>	D3531-1
<b>Inspection Dwg:</b> D3531 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	0.197	✓		u-Skno!	
Ø0.129	+0.005/-0.001	0.130	✓			
0.33	+/-0.030	0.33	✓			
2.840	+/-0.010	2.840	✓			
1.70	+/-0.030	1.70	✓			
1.45	+/-0.030	1.45	✓			
0.38	+/-0.030	0.38	✓			
0.19	+/-0.030	0.19	✓			
5.88	+/-0.030	5.88	✓			
12.66	+/-0.030	12.66	✓			
0.600	+/-0.010	0.600	✓			
1.77	+/-0.030	1.77	✓			
1.24	+/-0.030	1.24	✓			
1.16	+/-0.030	1.16	✓			

<b>Measured by:</b> mm	<b>Audited by:</b> DAS 27 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14/07/18	<b>Date:</b> 14/7/18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 120954 MWS  
14-07-10

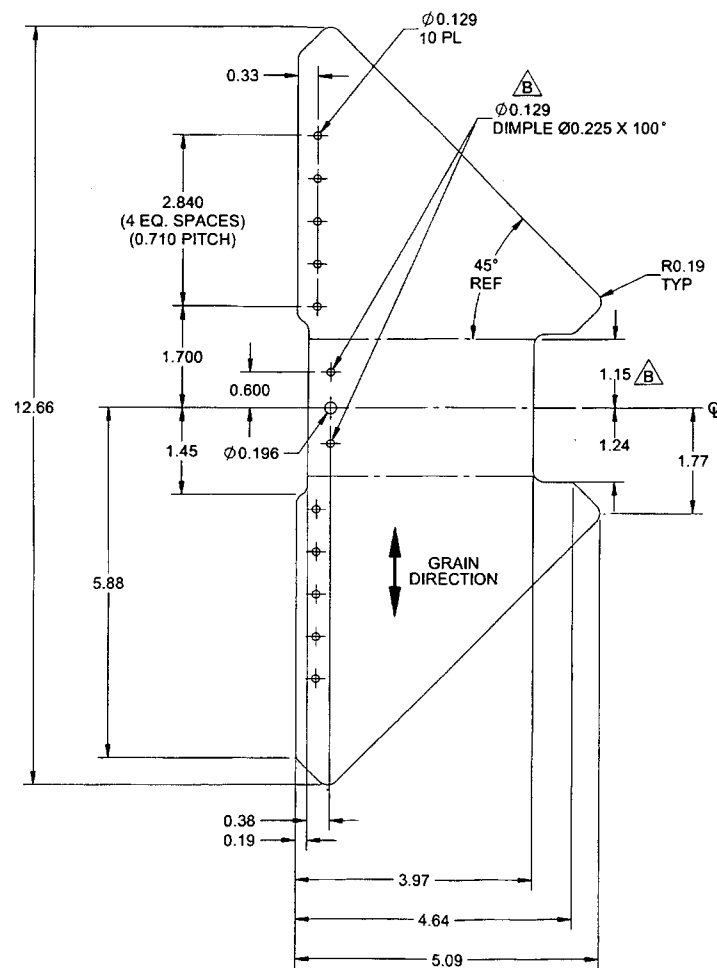
**RELEASED**  
12/10/15 UP

**D3531-1 BRACKET**

**NOTES:**

- 1) MATERIAL: MADE FROM D3531-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

DESIGN	CB	<b>DART AEROSPACE LTD</b>	
DRAWN	PC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AV	D3531	SHEET 2 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	BRACKET ASSEMBLY	NTS
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**D3531-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

**RELEASED**  
12/14/23

DESIGN	C.B.	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3531	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BRACKET ASSEMBLY	NTS
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